

SHIP July 23

Work Order ID 134854

134854

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Item ID: D407-836-017

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Crosstube Antenna Mount 407 Aft (P162-407A)

Start Date: 7/22/2015 Start Qty: 1.00

1

Cust Item ID:

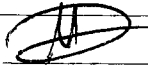
Required Date: 7/23/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: 

Date: 7.7.22

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
GA202-2	A								MCS JUL 23 2015
100	Document Control	0.00							
100									
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels as per PPP D407-836-017 CH001								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
27
9-89DAS
6
9-89

JUL 23 2015

DAS
27
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DAS
6
9-89

JUL 23 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Reference:

Run	Start	*NR1*
	Stop	*NR2*

mw JUL 23 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 134854

134854

Parent Item: D407-836-017

D407-836-017

Parent Item Name: Crosstube Antenna Mount 407 Aft (P162-407A)

Start Date: 7/22/2015

Required Date: 7/23/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.07.18 AS PER ECN13-561 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4853-1 *D4853-1* Top Bracket (Replaces P/N G13013-1)		Manufactured	No				Each	5.0000	**	1		DAS 27 9-89	
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST519			5					
					126142			5					
D4854-1 *D4854-1* Lower Bracket (Replaces P/N G13013-2)		Manufactured	No				Each	14.0000	**	1		DAS 27 9-89	
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					st526			14					
					109079			2					
					126502			12					
D4855-1 *D4855-1* Antenna Bracket (Replaces P/N G13013-3)		Manufactured	No				Each	14.0000	**	1		DAS 27 9-89 JUL 22 2015	
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					st526			14					
					126143			8					
					128258			6					

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Work Order ID: 134854

134854

Parent Item: D407-836-017

D407-836-017

Parent Item Name: Crosstube Antenna Mount 407 Aft (P162-407A)

Start Date: 7/22/2015

Required Date: 7/23/2015

Start Qty: 1.00

Required Qty: 1.00

D2732-030

Manufactured No

Each

86.0000

D2732-030

Rubber Cushion - 3"

DAS
6
9-89

Location

Loc Qty

Loc Code

FG

2

117118

2

134608

36

ST410

48

133074

48

Each

172.0000

AN4-16A

Purchased

No

AN4-16A

Bolt

DAS
6
9-89

Location

Loc Qty

Loc Code

FG

5

121541

5

ST343

167

M132317

167

Each

84.0000

AN4-11A

Purchased

No

AN4-11A

BOLT

DAS
6
9-89

Location

Loc Qty

Loc Code

FG

20

120731

20

ST325A

64

M128362

64

Each

711.0000

NAS1149D0432J

Purchased

No

NAS1149D0432J

WASHER

DAS
6
9-89

Location

Loc Qty

Loc Code

ST269

711

m131026

711

DAS
27
9-89

DAS
27
9-89

DAS
27
9-89

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Work Order ID: 134854

134854

Parent Item: D407-836-017

D407-836-017

Parent Item Name: Crosstube Antenna Mount 407 Aft (P162-407A)

Start Date: 7/22/2015

Required Date: 7/23/2015

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

Each

3,394.000

MS21042L4

Locknut

DAS

27

9-89

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DAS

6

9-89

Location

Loc Qty

Loc Code

FP001

2

m124231

2

GA

142

m127813

142

ST260a

170

m130799

56

m131803

6

m132262

108

ST305

3080

m128300

8

m130388

7

m130922

97

m131618

12

m132123

56

m132382

2900

4

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REFERENCE

5. PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -111	Part Number	Description
X					D206-836-011	CROSSTUBE ANTENNA MOUNT KIT 206A/B AND 206L FWD (P162-206)
	X				D206-836-013	CROSSTUBE ANTENNA MOUNT KIT 206L AFT (P162-206L)
		X			D407-836-015	CROSSTUBE ANTENNA MOUNT KIT 407 FWD (P162-407F)
			X		D407-836-017	CROSSTUBE ANTENNA MOUNT KIT 407 AFT (P162-407A)
				X	D206-836-111	CROSSTUBE ANTENNA MOUNT KIT UNIVERSAL (P162-U)
			1	1	D4853-1	TOP BRACKET (REPLACES P/N G13013-1)
1				1	D4853-3	TOP BRACKET (REPLACES P/N G13013-5)
		1		1	D4853-5	TOP BRACKET (REPLACES P/N G13013-7)
	1			1	D4853-7	TOP BRACKET (REPLACES P/N G13013-9)
			1	1	D4854-1	LOWER BRACKET (REPLACES P/N G13013-2)
1				1	D4854-3	LOWER BRACKET (REPLACES P/N G13013-6)
		1		1	D4854-5	LOWER BRACKET (REPLACES P/N G13013-8)
	1			1	D4854-7	LOWER BRACKET (REPLACES P/N G13013-10)
1	1	1	1	1	D4855-1	ANTENNA BRACKET (REPLACES P/N G13013-3)
2	2	2	2	2	D2732-030	RUBBER CUSHION (REPLACES P/N G13013-4)
2	2	2	2	2	AN4-16A	BOLT
2	2	2	2	2	AN4-11A	BOLT
8	8	8	8	8	NAS1149D0432J	WASHER
4	4	4	4	4	MS21042L4	LOCKNUT

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